

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.yy**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000037**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 04-Jan-2007**Location:** Changxing Island, Shanghai, China

<b>Submittals(New / Total):</b>	<b>CWR's: 0 / 0</b>	<b>HSR's: 0 / 0</b>	<b>NCR's: 0 / 0</b>
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Item	Title	Detail
1	Critical Weld Repairs (CWRs)	N/A
2	Heat Straightening Requests (HSRs)	N/A
3	Nonconformance Reports (NCRs)	N/A
4	Major component movement	Reviewed RT film for PQR 3G Flux Core Arc Welding (FCAW) procedure, HP-2006122 appears to comply
<p>Conducted welding of the following PQR test plates:</p> <p>1G Flux Core Arc Welding (FCAW) procedure identified as HP-2006107-9 on 26mm A709-345 plate (standard joint). Welding Complete</p> <p>3G Flux Core Arc Welding (FCAW) procedure identified as HP-2006129 on 75mm A709-345 (non-standard joint due to 20mm root). Welding is not complete and will continue tomorrow, 1-5-07.</p> <p>3G Flux Core Arc Welding (FCAW) procedure identified as HP-2006131 on 75mm HPS 485W (non-standard joint due to 20mm root). Welding is not complete and will continue tomorrow, 1-5-07.</p> <p>1G Submerged Arc Welding (SAW) procedure identified as HP-2006135 Minimum Heat Input plate on 26mm A709-345 (standard joint). Welding is not complete and will continue tomorrow, 1-5-07.</p>		
5	Meetings attended	N/A
6	Key conversations	ZPMC Testing Center Director Mr. Liu Liu spoke with QA regarding the width required for backing material on the thicker (75mm) PQR test plates. They are currently using 100mm wide plates and the Radiographic Testing (RT) company had suggested they use wider plates to ensure the tack welds did not show up in the weld zone, and to aid in achieving uniform film quality. QA responded that, although the code only requires a 75mm minimum width, the RT company's suggestion contained sound arguments

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## DAILY PROJECT JOURNAL

( Continued Page 2 of 2 )

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for increasing the width.

ZPMC Technical Department informed QA that they would like to begin testing the 2F and 2F HPS 485W fillet weld qualification even though they have not completed testing of the Groove Weld Test Plates. QA informed ZPMC that the State would witness the qualification testing, but stressed that the tests could become invalid if the Groove Weld Test Plates failed or the parameters qualified during the welding of the Groove Weld Test Plates were different from those used on the fillet weld qualification.

QA asked Mr. Liu Liu if the non-standard joints being qualified today (20mm root opening) and their intended locations had been submitted to the Engineer for approval. Mr. Liu Liu stated he did not know if they had been submitted or not. QA informed ZPMC that the State would witness the qualification testing, but stressed that final approval of the proposed weld joint was contingent upon the Engineer accepting the proposed joints and their intended locations.

Mr. Liu Liu and Mr. Chen Bin discussed the notching of the Heat Affected Zone (HAZ) Charpy-V Notch samples with QA.

7	Other important observations	N/A
8	Quality Assurance Inspectors per shift	1 AM 0 PM
9	Logistics	

<b>Inspected By:</b>	McClary,David	Quality Assurance Inspector
<b>Reviewed By:</b>	Lowry,Patrick	QA Reviewer